Work Order ID 111139

January-09-14 12:32:52 PM

111139

~~PRELIMINARY ISSUE~~

Item ID: D4634-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Fwd, Center Ceiling Panel

Start Date: 09/01/2014 **Start Qty:** 1.00 *1*

Required Date: 24/01/2014 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MP / MLJ **Date:** 14-01-09 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: D4634 ~~PD2 E~~ Rev E	DAS 27 9-89								
100	HAND FINISHING THERMOFORMING	0.00				x1			DL 14/01/12
100 Thermoform	**Memo** Cut Blanks	0.00							
Thermoforming Machine									
105	Dry Material	0.00				x1			DL 14/01/12
105 HandThermo	**Memo** Dry Sheet as per QSI022 POLYCARBONATE	0.00							
Hand Finishing Thermoforming	Temp: 245° F Time IN: 5:00 pm 14/01/11 Time OUT: 6:00 am 14/01/12								

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D4634-1 **Accept** *N9000040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Fwd, Center Ceiling Panel
Start Date: 09/01/2014 **Start Qty:** 1.00 *1*
Required Date: 24/01/2014 **Req'd Qty:** 1.00 *1*
Reference:
Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
110	THERMOFORMING MACHINE					X			DL 14/01/12
Thermoform	**Memo**	0.00							
Thermoforming Machine	Thermoform as per Dwg. D4634-1 and Folio FTA144 Dwg. Rev. E Folio Rev. B Visually inspect for proper formation and texture								
130		0.00							
130	HAND FINISHING THERMOFORMING					(X1)			14/01/20
Thermoform	**Memo**	0.00							
Thermoforming Machine	Trim to Finished Dimensions								
140	QC2- Inspect parts off machine FAI/FAIB	0.00				(1)			SAD 14/01/24
140									
QC	**Memo**	0.00							
Quality Control									

POSITIVE RECALL
EFFECTIVE 4.01.09 AUTH
RELEASED _____ DATE _____

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- ☐ Rework
- ☐ Scrap
- ☐ Use-as-is
- ☐ Suspected Unapproved

AGAINST DEPARTMENT/PROCESS

- ☐ Skid-tube
- ☐ Machining
- ☐ Thermoforming
- ☐ Large Fab
- ☐ Crosstube
- ☐ Small Fab
- ☐ Finishing
- ☐ Composite
- ☐ Water Jet
- ☐ Prod. Eng. Coor.
- ☐ Rec/Store/Packaging
- ☐ Supplier
- ☐ Engineering
- ☐ Quality
- ☐ Other
- ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Item ID: D4634-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Fwd, Center Ceiling Panel
Start Date: 09/01/2014 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 24/01/2014 **Req'd Qty:** 1.00 *1* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00 DAS 27 9:59 14/1/24				1			
150 QC Quality Control	**Memo**	0.00							
160		0.00							
160 Packaging Packaging	Packaging								
	Memo	0.00							
170	QC21- Final Inspection - Work Order Release	0.00							
170 QC Quality Control	**Memo**	0.00							

14-01-24

14-01-24

POSITIVE RECALL
EFFECTIVE _____ AUTH _____
RELEASED _____ DATE _____

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

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Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

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Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
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☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

January-09-14 12:32:59 PM

Work Order ID: 111139 *111139*

Parent Item: D4634-1 *D4634-1*

Parent Item Name: Fwd, Center Ceiling Panel

Start Date: 09/01/2014 **Required Date:** 24/01/2014

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev.A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B Dwg. Update 13/07/09 DL verf:DD IPP Rev C Dwg Update, Material Change 13/12/18 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,861.260	12.93	16			

MLEXS.093-F6006-07

GE PLASTICS LEXAN SHEET

**

Location	Loc Qty	Loc Code
MAT023	1861.26	
114459	229.26	
123105	38	
124501	1594	

DL 14/01/13

16 sq ft

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

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Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
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Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

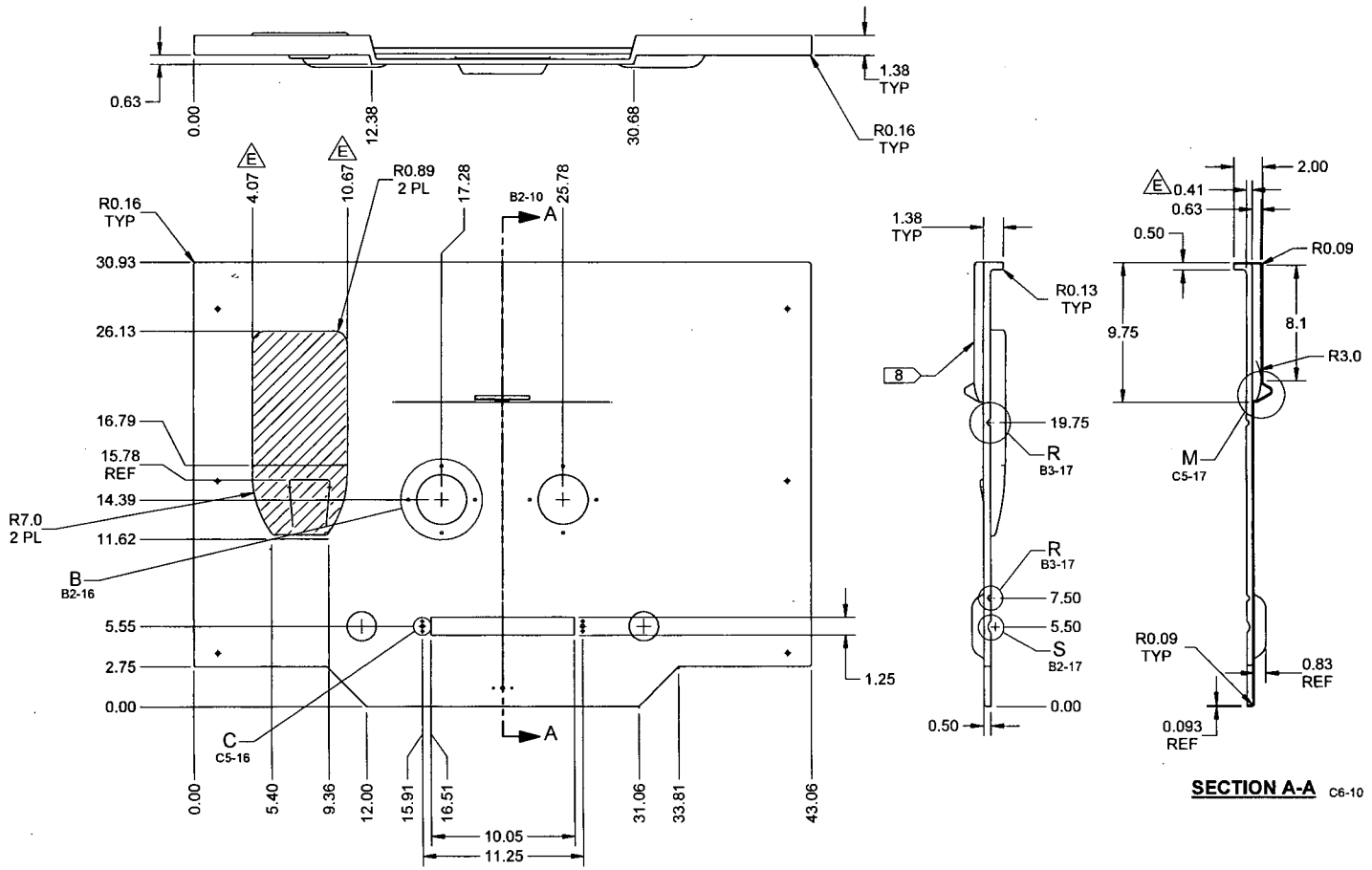
DART AEROSPACE LTD

Description:	PANEL	Work Order:	166139
Inspection Drawing:	D4634	Rev:	Part Number: D4634-1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.39	+/- 0.030	14.39	✓		tape	SFAB-21
5.55	+/- 0.030	5.55	✓		"	"
15.91	+/- 0.030				"	"
10.05	+/- 0.030	10.06	✓		"	"
11.25	+/- 0.030	11.25	✓		"	"
1.25	+/- 0.030	1.25	✓		"	"
17.23	+/- 0.030	17.25	✓		"	"
25.78	+/- 0.030	25.75	✓		"	"
12.06	+/- 0.030	12.06	✓		"	"
24.010	+/- 0.030	24.00	✓		"	"
11.66	+/- 0.030	11.66	✓		"	"
1.300	+/- 0.010	1.300	✓		Vern	SFAB-08
5.55	+/- 0.030	5.55	✓		"	SFAB-21
31.41	+/- 0.030	31.41	✓		"	"
Ø 0.129	-0.001	Ø 0.125			Vern	SFAB-08
Ø 0.250	-0.001	Ø 0.250	✓		Vern	"
Ø 2.030	+0.012 -0.001	2.010			Vern	"
Ø 3.50	+/- 0.030	3.50	✓		Vern	"
3.80	+/- 0.030	3.84	✓		Vern	"
0.63	+/- 0.030	0.66	✓		Vern	"
39.75	+/- 0.030	39.75	✓		tape	SFAB-21

Measured by: SAM	Checked By: DAS 27 9-89	QC inspector:	Engineering Approval (*if necessary*):
Date 14/01/24	Date 14/1/24	Date	Date



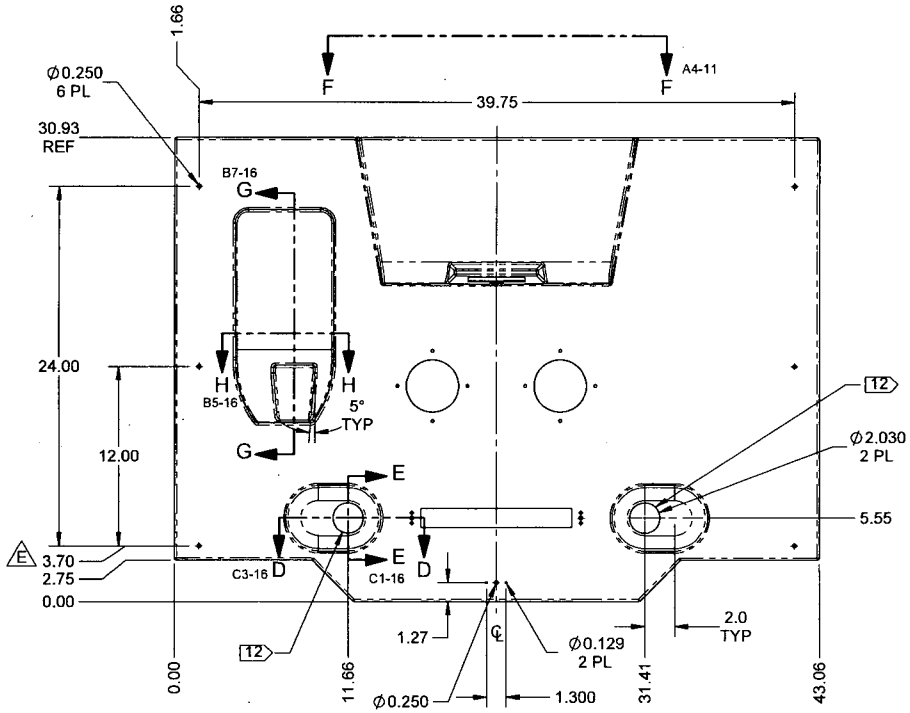
SECTION A-A C6-10

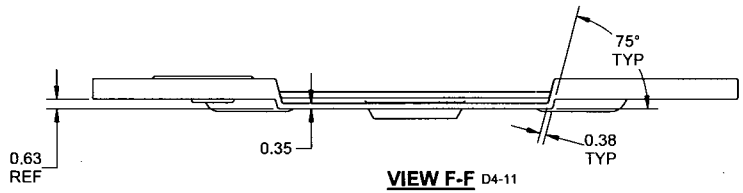
NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 5.65 lbs
8) TEXTURE ON THIS SIDE
9) 0.14 RADIUS NOT SHOWN FOR CLARITY
10) DRILL & TRIM D4634-1 PER TOOL DT9836
11) THERMOFORM PER QSI 022 USING DT9844 TOOL
MIN. THICKNESS AFTER FORMING:
SHADED AREA = 0.020
EDGES = 0.060
ELSEWHERE = 0.070
12) LOCATE ∅2.030 AT CENTER OF PROTRUDED SURFACE AS SHOWN

D4634-1 FWD, CENTER CEILING PANEL

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	SC	DRAWING NO. D4634 REV. PE1
MFG. APPR.		SHEET 10 OF 17
APPROVED		TITLE CENTER CEILING PANELS SCALE NTS
DE APPR.		
DATE	14.01.09	

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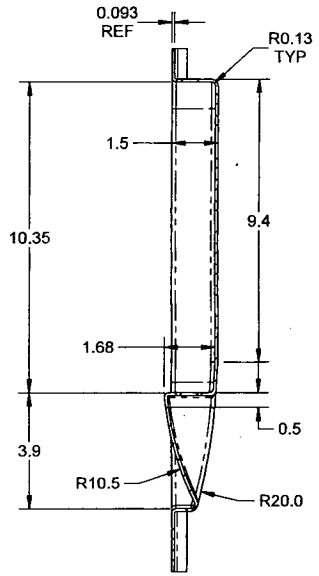


VIEW F-F D4-11

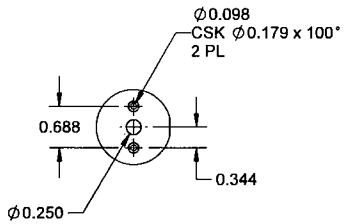
D4634-1 FWD, CENTER CEILING PANEL
AUXILIARY VIEW

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	DC	DRAWING NO. REV. PE1
MFG. APPR.		D4634 SHEET 11 OF 17
APPROVED		TITLE SCALE
DE APPR.		CENTER CEILING PANELS NTS
DATE	14.01.09	

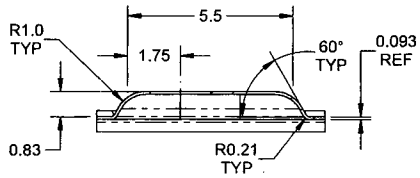
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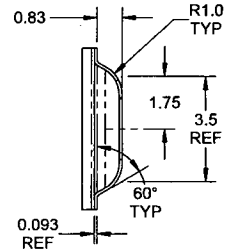
SECTION G-G C5-11
SCALE 4X



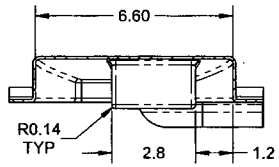
DETAIL C B7-10 B4-12 B4-14
SCALE 4X



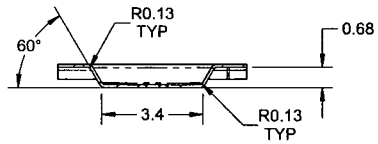
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SCALE 2X



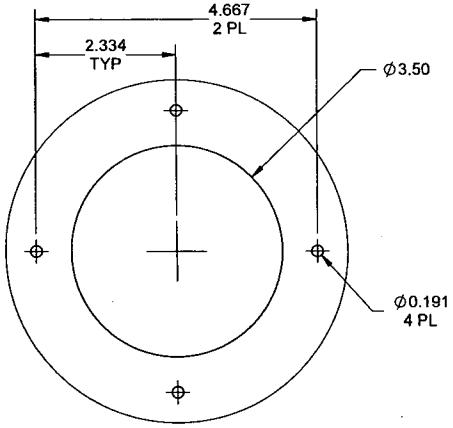
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SCALE 4X



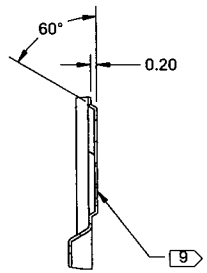
SECTION H-H C5-11
SCALE 2X



SECTION J-J B6-13
SCALE 2X



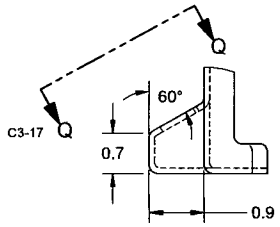
E **DETAIL B** B7-10
SCALE 4X
2 PL



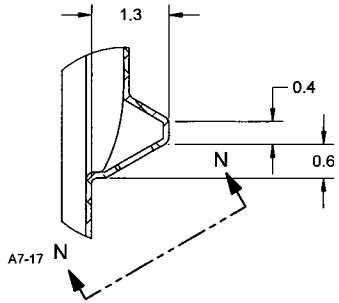
DETAIL L B2-13 C2-13 B2-14 C2-14
SCALE 4X
TYP

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	DC	DRAWING NO. D4634 REV. PE1 SHEET 16 OF 17
MFG. APPR.		
APPROVED		TITLE CENTER CEILING PANELS SCALE NTS
DE APPR.		
DATE	14.01.09	

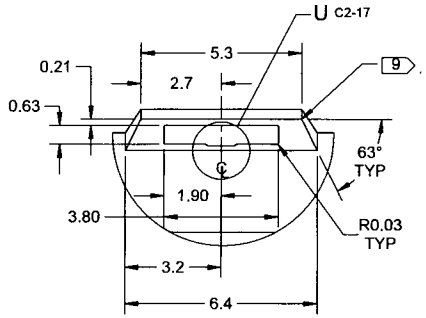
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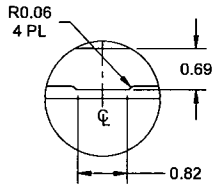
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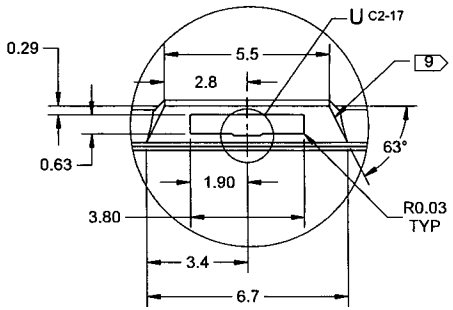
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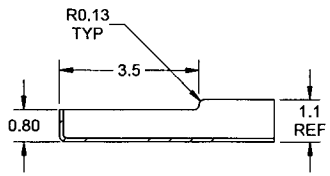
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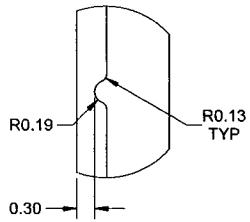
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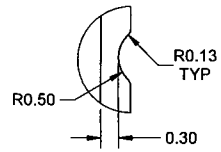
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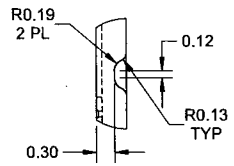
SECTION O-O B6-14
SCALE 1.3X



DETAIL R B3-10 C3-10 B2-12
SCALE 4X



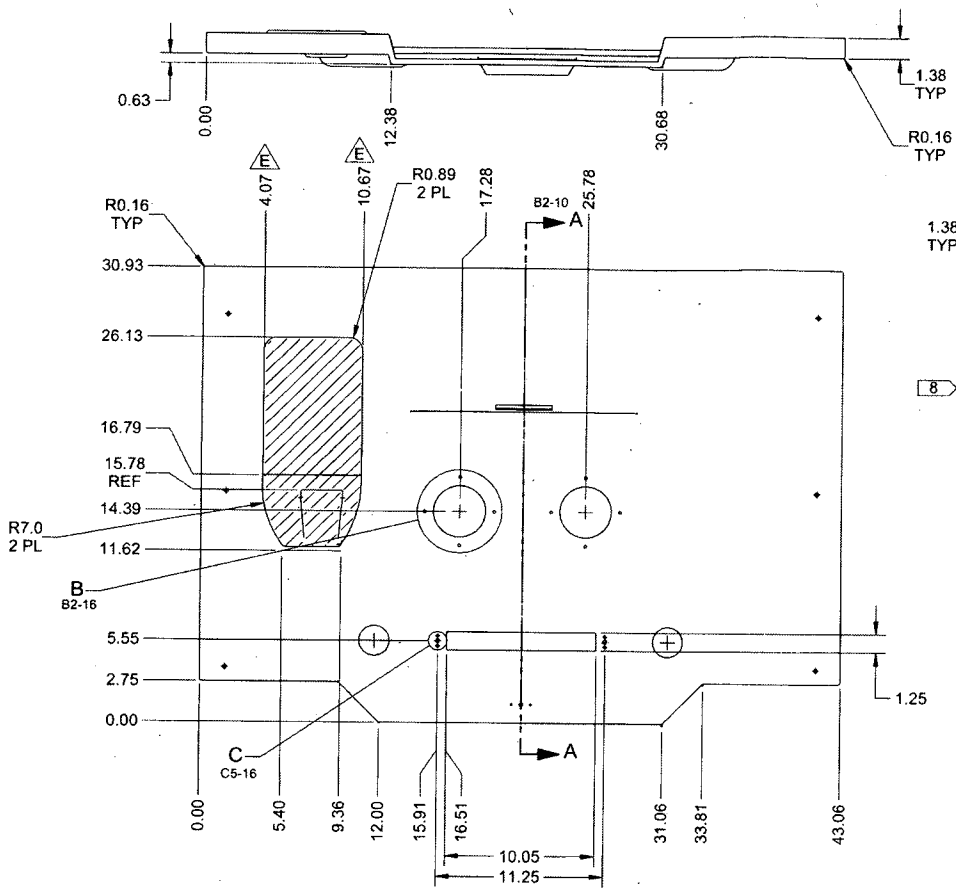
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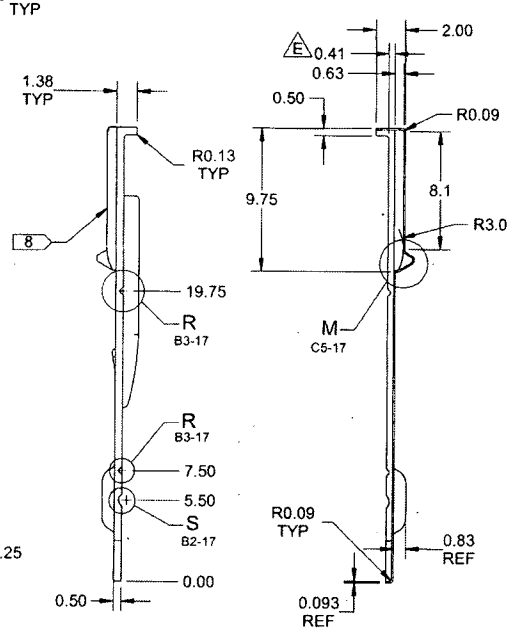


DETAIL T C2-14
SCALE 4X

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	BC	DRAWING NO. REV. PE1
MFG. APPR.		D4634 SHEET 17 OF 17
APPROVED		TITLE SCALE
DE APPR.		CENTER CEILING PANELS NTS
DATE	14.01.09	

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SECTION A-A C6-10

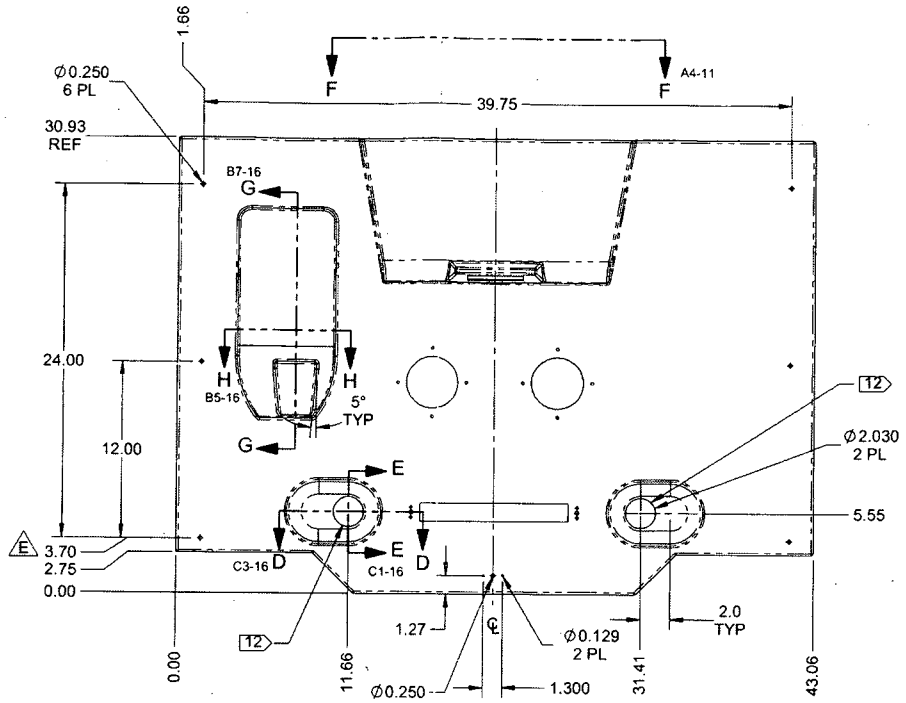
NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 5.65 lbs
8) TEXTURE ON THIS SIDE
9) 0.14 RADIUS NOT SHOWN FOR CLARITY
10) DRILL & TRIM D4634-1 PER TOOL DT9836
11) THERMOFORM PER QSI 022 USING DT9844 TOOL
MIN. THICKNESS AFTER FORMING:
SHADED AREA = 0.020
EDGES = 0.060
ELSEWHERE = 0.070
12) LOCATE ∅2.030 AT CENTER OF PROTRUDED SURFACE AS SHOWN

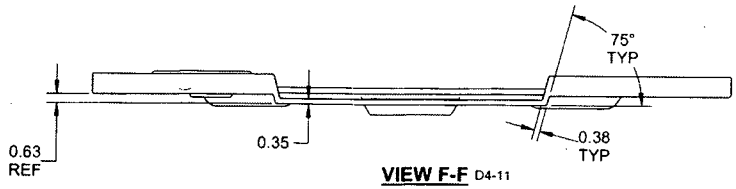
D4634-1 FWD, CENTER CEILING PANEL

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2014 -01- 22

DESIGN	RF	**DART AEROSPACE LTD**	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. E
MFG. APPR.		D4634	SHEET 10 OF 17
APPROVED		TITLE	SCALE
DE APPR.		CENTER CEILING PANELS	NTS
DATE	14.01.09		

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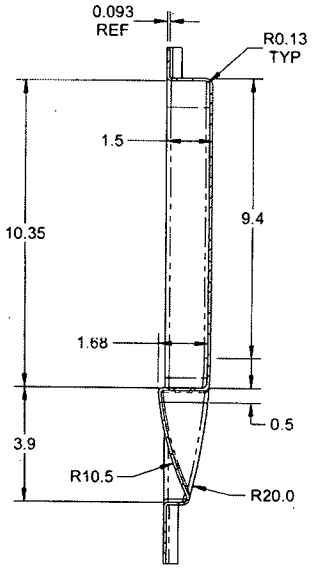
VIEW F-F D4-11

D4634-1 FWD. CENTER CEILING PANEL
AUXILIARY VIEW

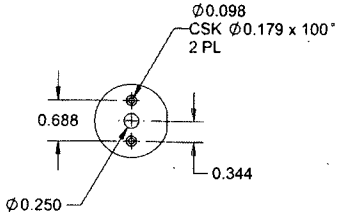
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2014 -01- 22

DESIGN	RF	**DART AEROSPACE LTD**	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. E
MFG. APPR.		D4634	SHEET 11 OF 17
APPROVED		TITLE	SCALE
DE APPR.		CENTER CEILING PANELS	NTS
DATE	14.01.09		

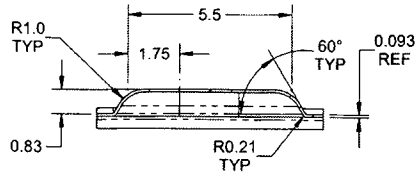
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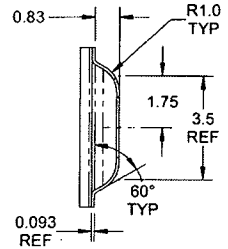
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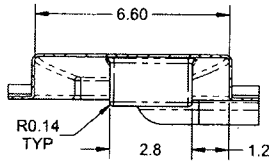
DETAIL C B7-10 B4-12 B4-14
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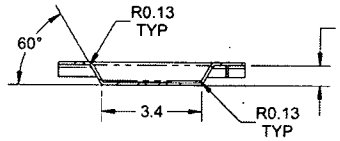
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SCALE 2X



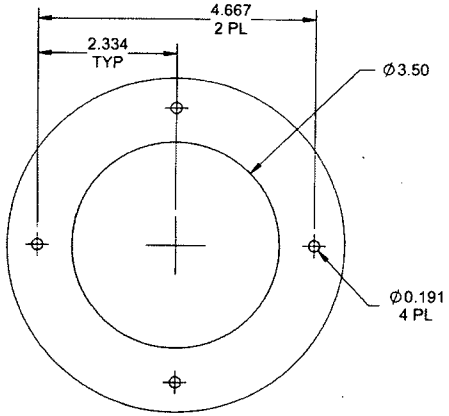
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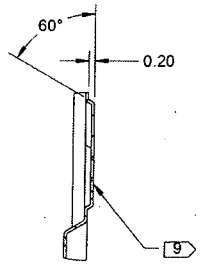
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SECTION J-J B6-13
SCALE 2X



(E) **DETAIL B** B7-10
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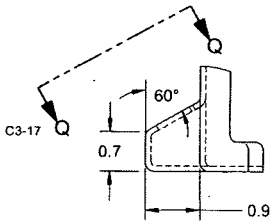


DETAIL L B2-13 C2-13 B2-14 C2-14
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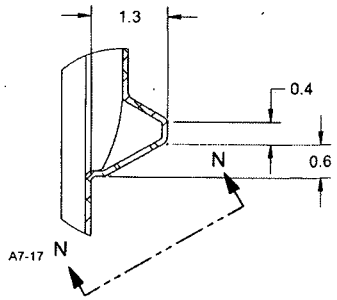
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CHECKED	BC	DRAWING NO. D4634 REV. E SHEET 16 OF 17
MFG. APPR.		
APPROVED		TITLE CENTER CEILING PANELS SCALE NTS
DE APPR.		
DATE	14.01.09	

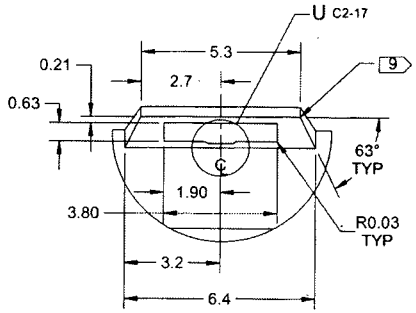
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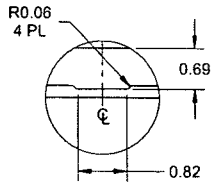
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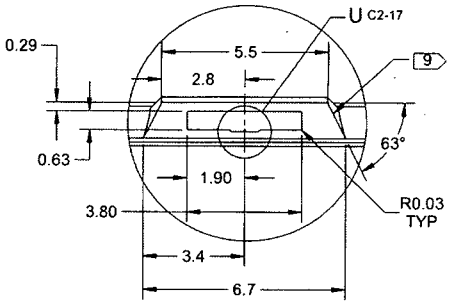
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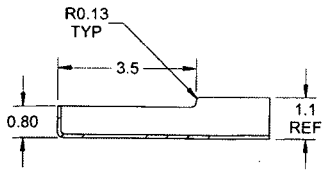
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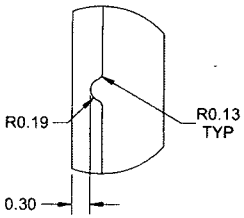
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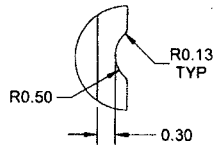
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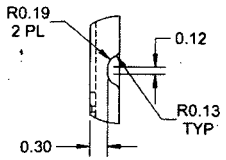
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DETAIL R B3-10 C3-10 B2-12
SCALE 4X



DETAIL S B3-10 C2-12
SCALE 4X



DETAIL T C2-14
SCALE 4X

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DRAWN	RF	
CHECKED		DRAWING NO. D4634 REV. E
MFG. APPR.		SHEET 17 OF 17
APPROVED		TITLE CENTER CEILING PANELS SCALE NTS
DE APPR.		
DATE	14.01.09	

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